

Friday, June 04, 2010 9:18:54 AM



Accept

**Setup Start**

Stop

Item Name: Plug Assembly

Start Date: 6/4/2010 **Start Qty:** 80.00

**Cust Item ID:**

Required Date: 6/10/2010 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-04

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

0.00

Quality Control

MUE
10/06/10

80 C

80 ~~9~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries







Work Order ID 59421

Friday, June 04, 2010 9:18:54 AM

Page 2

Item ID: D3492-043 Accept  Setup Start 
Revision ID:
Item Name: Plug Assembly Stop 
Start Date: 6/4/2010 Start Qty: 80.00  Cust Item ID:
Required Date: 6/10/2010 Req'd Qty: 80.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							 BR 10-6-11
140  Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	Memo	0.00							
	(Flat End Only) <input type="checkbox"/> START TIME: 2:30pm <input type="checkbox"/> OVEN								
	TEMPERATURE: 320°F <input type="checkbox"/> FINISH TIME: 3:00pm								
150  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							 10 06 15 

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 59421



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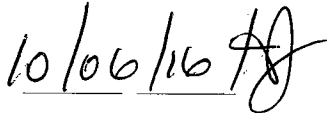


Page 3

Item ID: D3492-043 Accept  Setup Start 
Revision ID:
Item Name: Plug Assembly Stop 
Start Date: 6/4/2010 Start Qty: 80.00  Cust Item ID:
Required Date: 6/10/2010 Req'd Qty: 80.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging	Identify as per dwg & Stock Location: <u>FP-13</u> Memo	0.00 0.00		<u>1100100110</u>		<u>80</u>	<u>0</u>		
170  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

10/06/10 
UMF
10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 04, 2010 9:18:59 AM

Page 1

Work Order ID: 59421



Parent Item: D3492-043



Parent Item Name: Plug Assembly

Start Date: 6/4/2010

Required Date: 6/10/2010

Comments:

IPP Rev: A 06.03.21 New Issue JLM
IPP Rev: B 06-08-28 As per Rev B JLM
IPP Rev: C 07-12-06 Rev C dwg DD verified by: EC
IPP Rev: D 08-05-07 add note to count qty DD verified by: JLM

Start Qty: 80.00

Required Qty: 80.00

M6061T6R0.750

Purchased

No

100

f

37.1168

0.0625

5.263158



6061-T6 Round Bar .750"

Location

Loc Qty

Loc Code

MAT012

37.11684211

— 112041

30

112442

7.11684211

525 SN 10/06/10

W/O:		WORK ORDER CHANGES					
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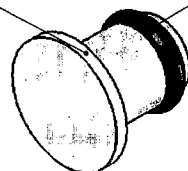
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NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59421
BS 10-6-04

UNDER REVIEW
03.04.08
OK ASS 08.11.12

DEO ATTACHED

RELEASED
01.11.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>AL</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3492 REV. C SHEET 1 OF 2 TITLE PLUG SCALE 2:1 COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<u>AL</u>		
CHECKED	<u>AL</u>		
MFG. APPR.	<u>AL</u>		
APPROVED	<u>AL</u>		
DE APPR.	<u>AL</u>		
DATE	07.10.05		

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>B</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

w/o 59421

WAS:

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

RELEASED
08/11/05 MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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